

Date: Friday, 9/21/2007 12:59:41 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, INBOARD, RS, 206  
 Job Number : 34781  
 Estimate Number : 10821  
 P.O. Number :  
 This Issue : 9/21/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : MACHINED PARTS  
 Previous Run : 32625  
 Written By :  
 Checked & Approved By : 07.09.24  
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house  
 processEC  
 Est Rev:D As per Rev D 07-03-19 JLM

Part Number : D26662  
 Drawing Number : D2666 REV.D  
 Project Number : N/A  
 Drawing Revision : D  
 Material :  
 Due Date : 10/10/2007 Qty: 12 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
 7075-T7351 2X6X6.25  
 Issue material from stock:  
 Cut Size 2.0 x 6.25 X 6.0  
 Grain Along Long 6.0 Length

Batch No: B31386 X8  
B25345 X4 B6 07.09.26 (12)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Program batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 3-Fixturing Inspection last completed on N/A by N/A  
 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet  
 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  
 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  
 7- Deburr

B6 07.09.26 (12)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

B6 07.09.26 (12)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B6 07.09.26 (12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 12:59:41 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 34781

Part Number: D26662

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SL 04/09/26

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-A

07/09/27

(12x)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105 068

BL

07-09-28

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/10/01

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57426

07/10/01

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.01

Job Completion



UL J10-01

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

8

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	34781
<b>Description:</b> 206 Saddle, Inboard, Right side		<b>Part Number:</b>	D2666-2
<b>Inspection Dwg:</b> D2666 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.126	.126	.126	.126		
B	0.100	0.140		.120	.120	.120	.120		
C	2.470	2.510		2.495	2.495	2.495	2.495		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.227	.227	.227	.227		
F	1.313	1.343		1.330	1.330	1.330	1.330		
G	0.240	0.260		.255	.255	.255	.255		
H	0.615	0.685		.640	.640	.640	.640		
I	1.125	1.145		1.138	1.138	1.138	1.138		
J	0.990	1.010	*	1.000	1.000	1.000	1.000		
K	0.235	0.240		.239	.239	.239	.239		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.116	.116	.116	.116		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.010	6.010	6.010	6.010		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.505	.505	.505	.505		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.361	1.361	1.361	1.362		
V	0.315	0.322		.319	.319	.319	.319		
W	0.540	0.560		.556	.556	.556	.556		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SL
Date:	07.09.16

Audited by:	SL
Date:	07/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>34781</b>
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	<b>D2666-2</b>
<b>Inspection Dwg:</b> D2666 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 <sub>5</sub>	2 <sub>6</sub>	3 <sub>7</sub>	4 <sub>8</sub>		
A	0.100	0.140		.126	.126	.126	.126		
B	0.100	0.140		.120	.120	.120	.120		
C	2.470	2.510		2.495	2.495	2.495	2.495		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.227	.227	.227	.227		
F	1.313	1.343		1.331	1.331	1.331	1.331		
G	0.240	0.260		.255	.255	.255	.255		
H	0.615	0.685		.640	.640	.640	.640		
I	1.125	1.145		1.140	1.140	1.140	1.140		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.239	.239	.239	.239		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.115	.115	.115	.115		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.010	6.010	6.010	6.010		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.505	.505	.505	.505		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.319	.319	.319	.319		
W	0.540	0.560		.557	.557	.557	.557		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	RF
Date:	07-09-26

Audited by:	SL
Date:	07/09/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>34781</b>
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	<b>D2666-2</b>
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				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.126	.126	.126		
B	0.100	0.140		.120	.120	.120	.120		
C	2.470	2.510		2.495	2.495	2.495	2.495		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.227	.227	.227	.227		
F	1.313	1.343		1.130	1.120	1.130	1.130		
G	0.240	0.260		.255	.255	.255	.255		
H	0.615	0.685		.650	.650	.650	.650		
I	1.125	1.145		1.140	1.140	1.140	1.140		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.239	.239	.239	.239		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.115	.115	.115	.115		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.010	6.010	6.010	6.010		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.506	.506	.506	.506		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.319	.319	.319	.319		
W	0.540	0.560		.556	.556	.556	.556		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	07.04.26

Audited by:	<i>J.L.</i>
Date:	07/07/26

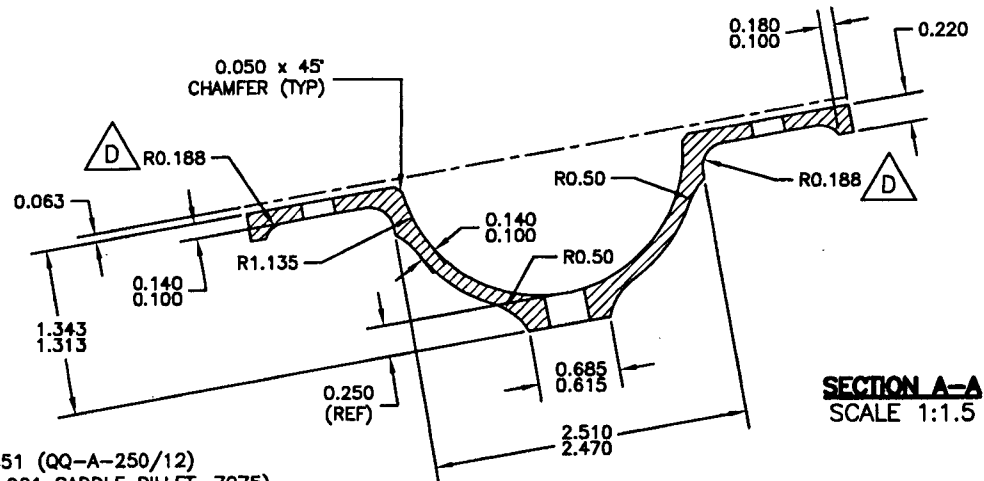
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
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D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

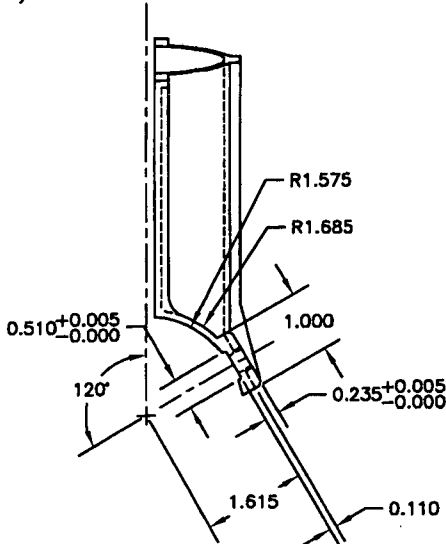
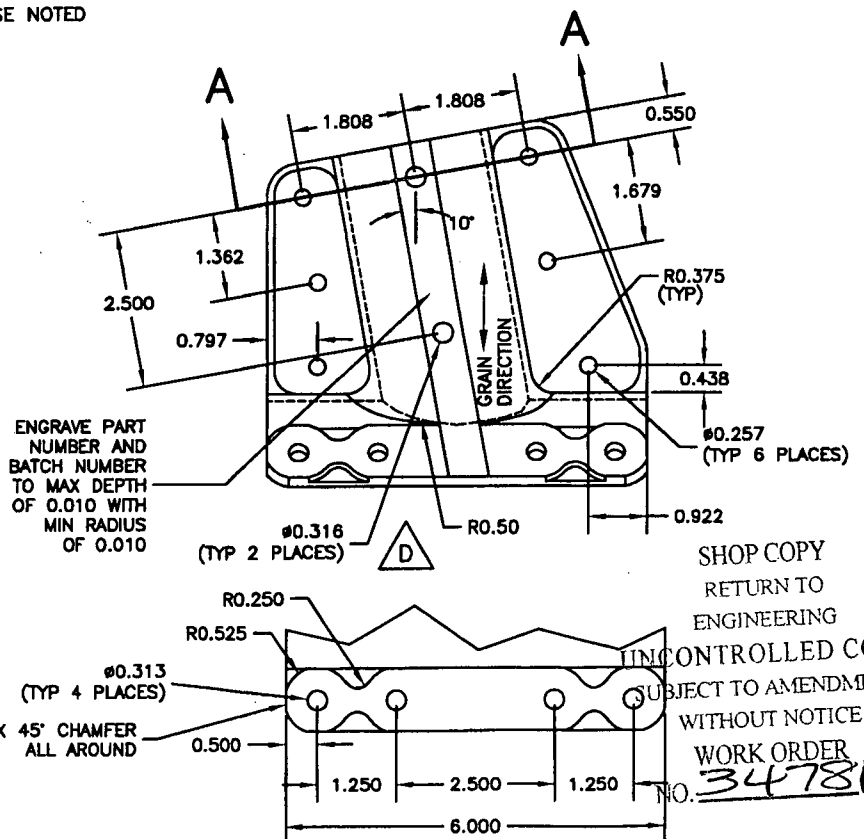
RELEASED

07.02.12 #



## NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34781

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